

# Work Order ID 61647

Tuesday, August 31, 2010 9:48:38 AM



Page 1

Item ID:	D2230-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Lug					
Start Date:	8/31/2010	Start Qty: 80.00		Cust Item ID:		
Required Date:	9/7/2010	Req'd Qty: 80.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date: 10-8-31	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2230	Rev G								

100		BAND SAW	0.00	
	Bandsaw	Memo	0.00	B.A 10/09/21
	Jeaspa Bandsaw	Cut D2423 extrusion to 0.82"		
		Batch: B45800		

110		HAAS CNC VERTICAL MACHINING #1	0.00	
	HAAS 1	Memo	0.00	
	HAAS CNC vertical machine #1	1-Machine per folio FA927		
		FOLIO REV: _____		
		DWG REV: _____		
		Check for crack while loading into the machine		
		2- deburr		

Issue PO 12709  
Machine per dwg D2230 Rev.G

CY 10/10/07 (80)

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Item ID: D2230-3

Accept



Setup Start



Revision ID:

Item Name: Lug

Stop



Start Date: 8/31/2010 Start Qty: 80.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC  
Quality Control

QC2 - Inspect parts off machine FAI/FAIB

0.00

Receive + Inspect for transit damage

Memo

0.00

Ensure C of C attached

8/31/10 80

130



QC  
Quality Control

QC8 - Inspect parts - second check

0.00

QC6  
Memo

0.00

8/10/10/25

Counters

150

150



HandFinish  
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

8/10-10-25

85

# Work Order ID 61647

Tuesday, August 31, 2010 9:48:38 AM



Page 3

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 8/31/2010 Start Qty: 80.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

*M 10/10/24*

*80*

*9*



QC

Memo

0.00

Quality Control

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

*BR 10-10-25.*

*80.*



Powdercoat

Memo

0.00

Powder Coating

START TIME: *3:40*  
OVEN TEMPERATURE: *320°*  
FINISH TIME: *4:10.*

180

QC3- Inspect Part Finish

0.00

*=7 M 10/10/25*

*80*



QC

Memo

0.00

Quality Control

**Work Order ID 61647**

Tuesday, August 31, 2010 9:48:38 AM



Page 4

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 8/31/2010 Start Qty: 80.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Identify as per dwg &amp; Stock Location: 476

0.00



Packaging

Memo

0.00

Packaging

Per 4/14/26 80

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/26

ME 10-10-26

# Picklist Print

Tuesday, August 31, 2010 9:48:42 AM

Page 1

Work Order ID: 61647



Parent Item: D2230-3



Parent Item Name: Lug


Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP ☐ D ☐ 00.05.18 ☐ Added inspection level 8, and removed P/O for powder coat ☐ EC  
25 JLM VERIFIED BY:EC  
☐ IPP REV :E NEW FOLIO # 10-05-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423  Lug Extrusion		Manufactured	No			100	f	364.5171	0.0683	5.751579			

Location

Loc Qty

Loc Code

MAT06

364.5170795

43722

180

✓45800

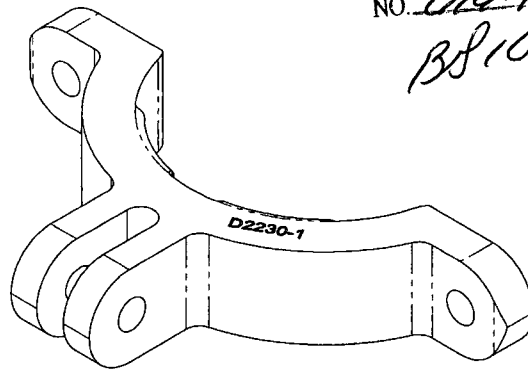
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5.7515  $\pm$

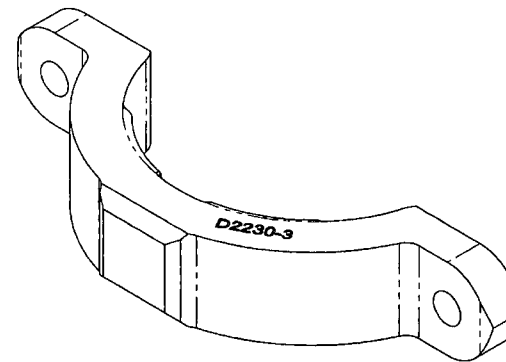
S.A 10/09/21

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 61447

*BS10-8-31*



**D2230-1 MOUNTING LUG**



**D2230-3 MOUNTING LUG**

**RELEASED**  
*09/01/16*



**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF  $0.010 \pm 0.005$  IN THIS LOCATION, WITH TOOL TIP RADIUS OF  $0.015 \pm 0.005$ .
- 7) WEIGHT: -1: 0.16 lbs  
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2230	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

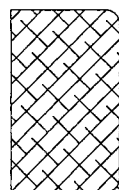
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

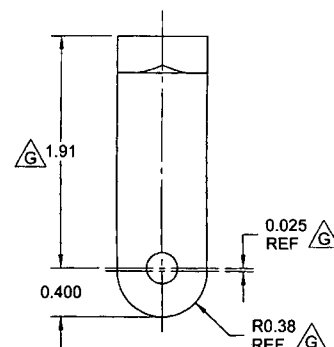
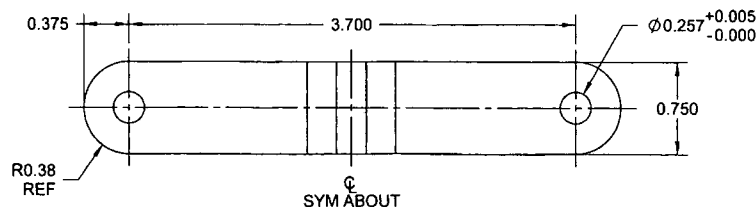
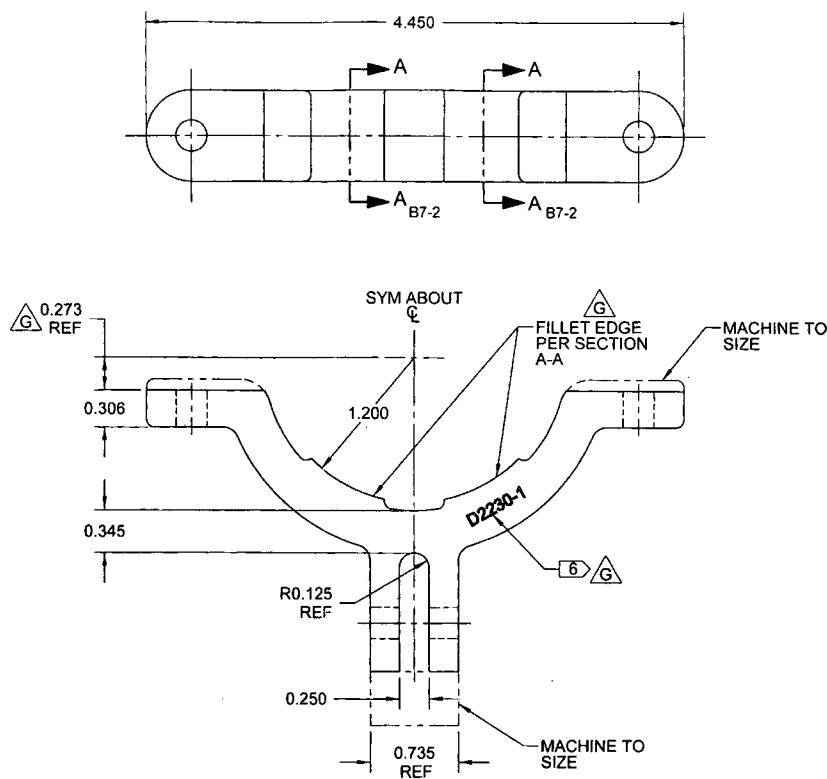
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**SECTION A-A** D4-2  
SCALE 2X



R0.06 MIN - R0.10 MAX  
2 PL



**RELEASED**  
09/06/25/17

**D2230-1 MOUNTING LUG**

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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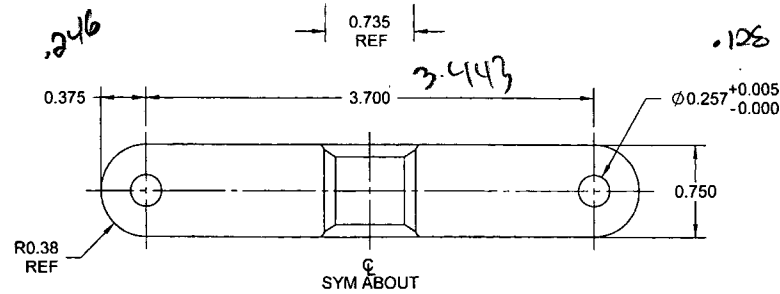
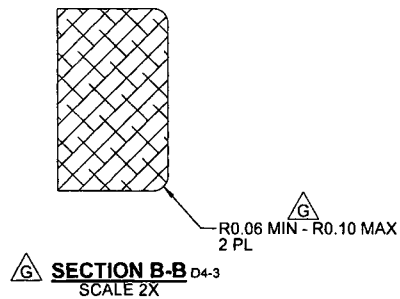
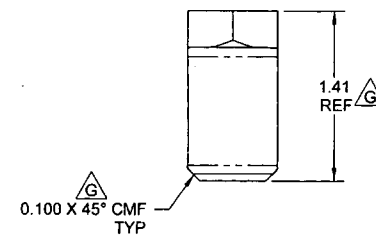
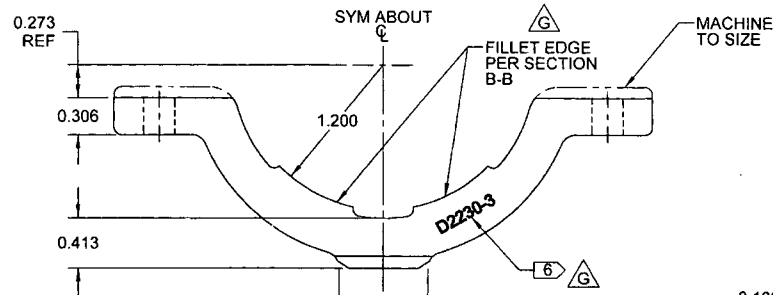
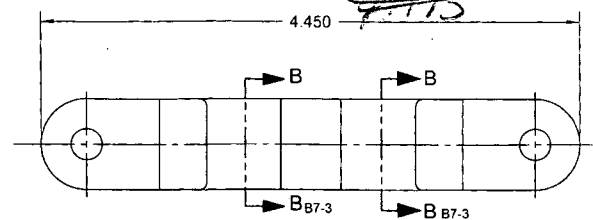
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D2230-3 MOUNTING LUG**

**RELEASED**  
09/06/25

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

100	D2230-3	Mounting Lug
80	D2230-3	Mounting Lug
50	D2230-1	Mounting Lug

S  
10/10/25

12709

12709

12709

MATERIAL: Supplied by DART D2324 45800

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, October 22, 2010